

Work Order ID 52203

September 17, 2009 1:55:45 PM



Page 1

Item ID: D3140-91

Revision ID: F

Item Name: Doubler

Start Date: 9/17/09

Start Qty: 4.00

Required Date: 9/18/09

Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

QC:

CZ

Date:

Date: 09/09/17

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3140

Rev F

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3140: **ENSURE THAT GRAIN DIRECTION IS
CORRECT*** 1-Dwg Rev: F Prog Rev: F 2-Deburr if
necessary

IB 9-9-17

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-9-17

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 8/21/18

(46) f

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Page 2

Item ID: D3140-91

Accept



Setup Start



Revision ID: F

Stop



Item Name: Doubler

Start Date: 9/17/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Form as per Dwg D3140 12-Scuff surfaces with 80grit sandpaper per
QSI 0061 13-Deburr. 1 No sharp edges

SB 09/09/18

140

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

2) SC 09/02/18



f

150

0.00



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

MD 09/10/18



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Item ID: D3140-91

Revision ID: F

Item Name: Doubler

Start Date: 9/17/09 Start Qty: 4.00

Required Date: 9/18/09 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

0909-18

0

9/9/18 @ SP

09109/21

mf 09-09-18

Picklist Print

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Page 1

Work Order ID: 52203

Parent Item: D3140-91RevF

Parent Item Name: Doubler

Comments:

Start Date: 9/17/09

Required Date: 9/18/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	96.7095	0.6211	.9316		



2024-T3 .032 sheet

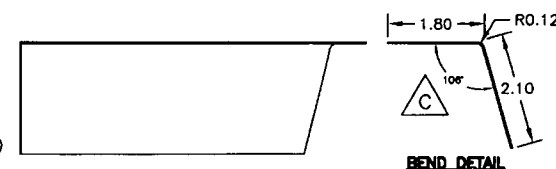
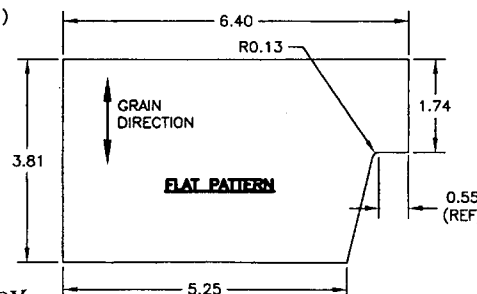
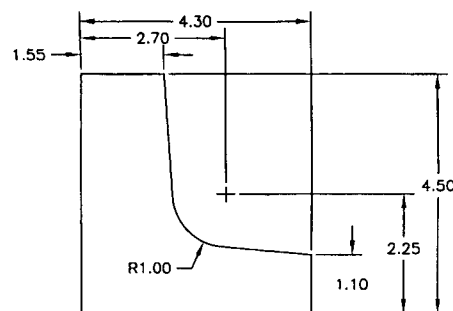
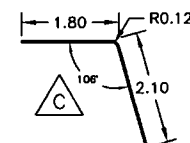
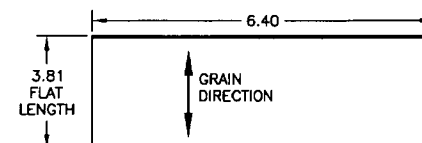
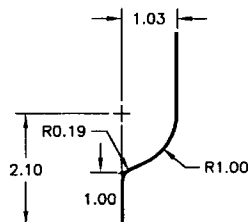
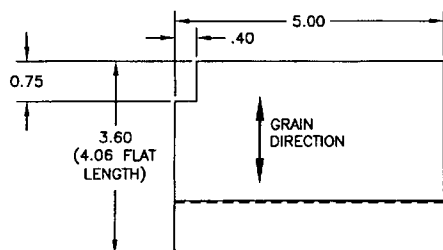
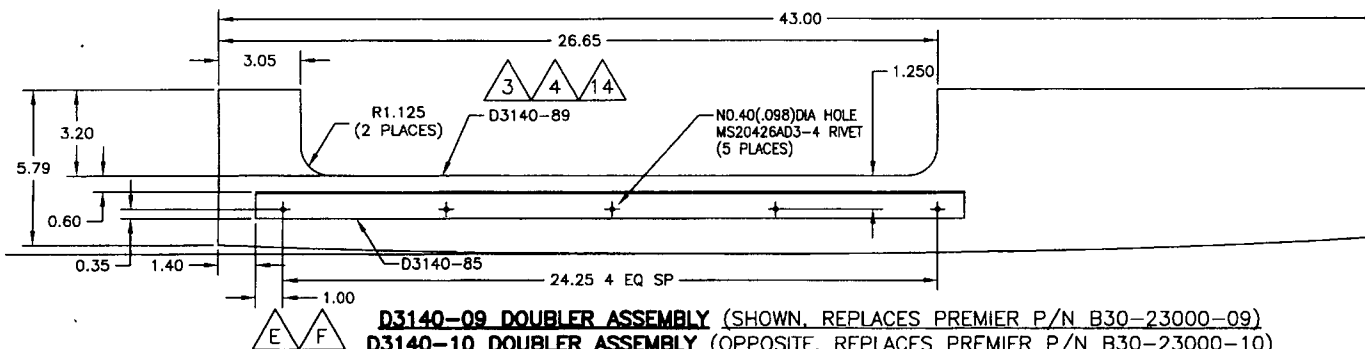
129-9-17

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

MAT	96.70953158
102942	1.5
105555	5
106272	5.3
108595	3
109240	7.02
110778	23.9106316
111699	47.9789
18147	3

105555



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DESIGN	4	DRAWN BY	CB	DART	DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
CHECKED	John	APPROVED	John	DRAWING NO.	D3140
DATE	06.10.06	TITLE	DOOR	REV. F	SHEET 5 OF 7
				SCALE	NTS